

Date: Tuesday, 31/03/2009 1:04:19 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STOP
Job Number : 46735	
Estimate Number : 10514	
P.O. Number :	Part Number : D28051
This Issue : 31/03/2009 S.O. No. :	Drawing Number : D2805 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 41081	Material :
Written By :	Due Date : 07/04/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 09.03.31</u>	
Comment : Est: B 00.11.14 Revised Finishing step to Acid etch and Alodine EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01500	6061-T6 Bar 1.50 x 1.50
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not out of comp

Comment: Qty.: 0.2756 f(s)/Unit Total : 5.5125 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch: M108962X50"

88 09/04/01

2.0	BAND SAW	BAND SAW
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(20)

Comment: BAND SAW

Cut Bar: 3-150" Long +0.010/-0.030"

88 09/04/01

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr

Identify as D2805-1

DTJ 09/04/02

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DTJ 08/04/02

(20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

DTJ 09/04/03

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 46735

Part Number: D28051

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(X20)

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

mol/FL

09/04/06

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



(20)

Comment: INSPECT ALODINE

FL 09/04/06

8.0 PACKAGING 1 PACKAGING RESOURCE #1



(30x)

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *CS*

9/4/06

SD

9.0 QC21 FINAL INSPECTION/W/O RELEASE



09/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46735
Description: Stop		Part Number: D2805-1
Inspection Dwg: D2805 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST





☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.974	+/-0.010	2.974	✓			
0.240	+/-0.010	0.240	✓			
0.100 chamfer	+/-0.010	0.095	✓			
1.420	+/-0.001	1.419	✓			
1.125	+/-0.010	0.129	✓			
0.250	+0.005/-0.000	0.2505	✓			
0.250	+/-0.010	0.253	✓			
1.500	+/-0.010	1.493	✓			
1.000	+/-0.010	0.994	✓			
0.875	+0.001/-0.000	0.876	✓			
0.438	+0.001/-0.000	0.438	✓			
Ø0.191	+0.005/-0.000	0.196	✓			
2.689	+/-0.010	2.689	✓			

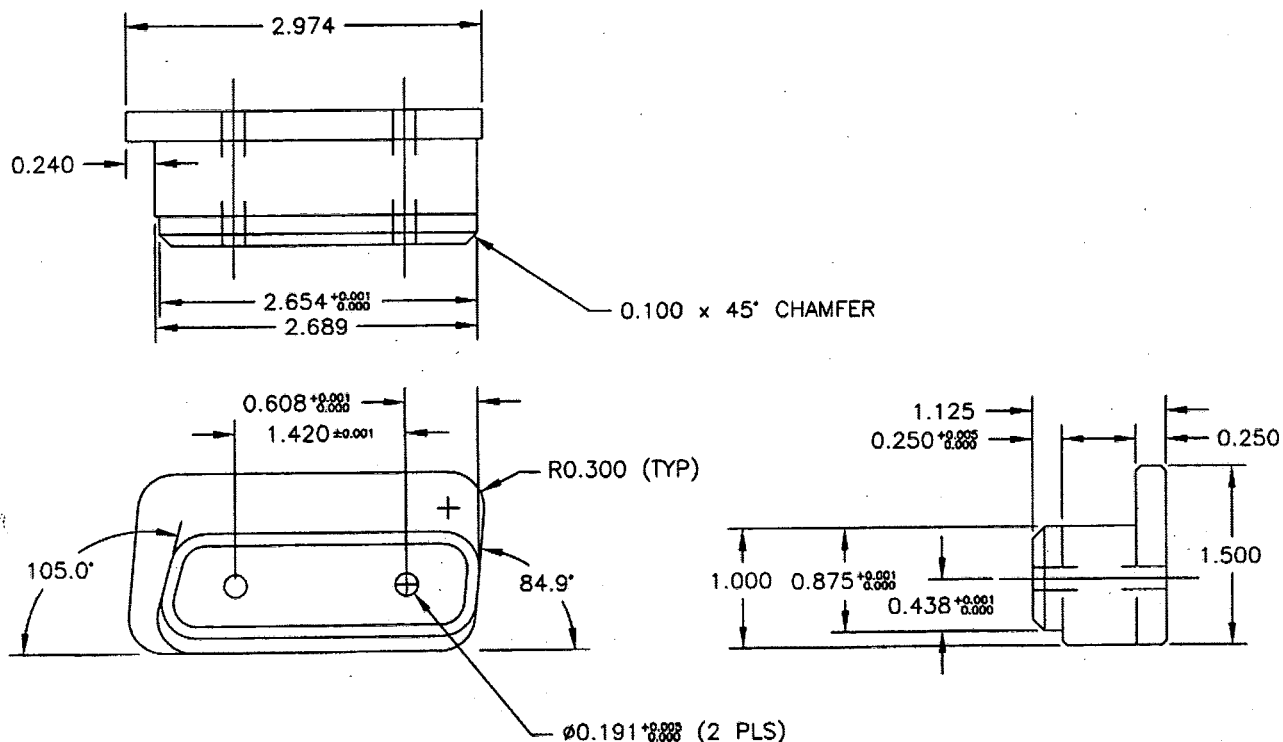
Measured by: DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/04/02	Date: 09/04/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM [Signature]	[Signature]



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2805	REV. B SHEET 1 OF 2
DATE 01.03.13				TITLE STOP	SCALE 2:3
A	00.10.31		NEW ISSUE		
B	01.03.13		ADD -3/-4		

RELEASED
01.03.16



D2805-1 (SHOWN)
D2805-2 (OPPOSITE)

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 26135

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

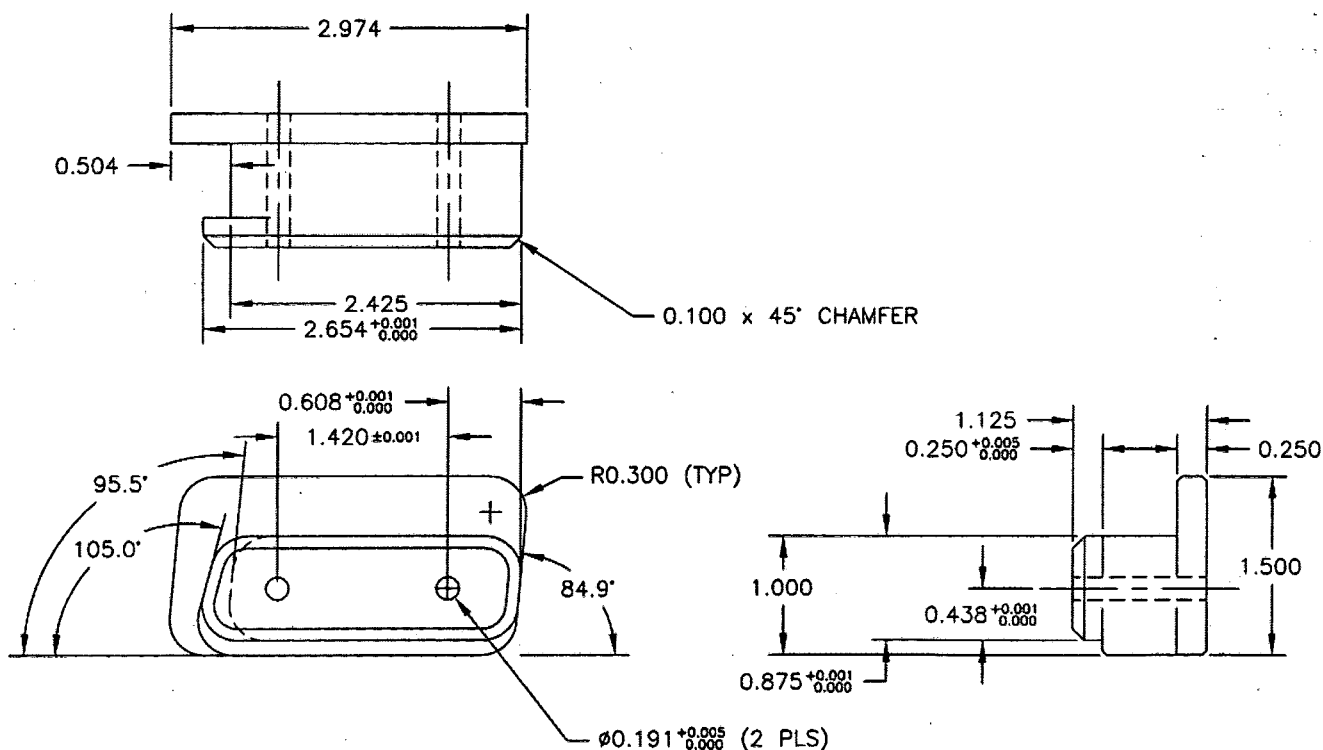
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2805	REV. B SHEET 2 OF 2
DATE 01.03.13		TITLE STOP	SCALE 2:3

RELEASED
01.03.16 *[Signature]*



D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

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WORK ORDER
NO. 46735

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BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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